

Work Order ID 50724

July 21, 2009 12:41:56 PM



Page 1

Item ID: D2017-121

Accept



Setup Start



Revision ID: E

Stop



Item Name: Step Strut

Start Date: 7/06/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/06/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2017

Rev F

100

QC5- Inspect part completeness to step on W/O

0.00

2009/09/14

QC

Memo

0.00

Quality Control

(Pb) →

110

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

11112260

0.00

⇒ 11 09/09/14

Powdercoat

Powder Coating

Memo

START TIME: 11:15 AM OVEN TEMPERATURE:
11:45 PM FINISH TIME: 400°F

(V2) Q

120

QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

BR 09-09-14
0.00

(2)

W/O: 50124

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.09.09	90	Punch tube as per Dwg. ~ Deben <i>100909/15</i>	SP	09/09/08			<i>3/09</i>
			M/L	09/09/10	(2x)		

Part No: D2017-121 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2017-121

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Setup

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Cust Item ID:

Required Date: 7/06/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

130



Packaging

Packaging

Identify as per dwg & Stock Location: 152

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

9/9/15

SP

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/9/15 JG

BD 09-9-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Status	Item ID	Rev	Name	Start Date	Quantity	Per Job	Op Date	Scrap %	Quality	meind	N/C	I/CX	I/Sort	me	Offset	in	Ty	1 Per	Och to	Yore	Ce	Last	Ind	Da
✓	M304TR0.750W.049		304 RD Tube .750...	6/24/09	1.0500	f		100	5	0.0...								1	0	M...			6/3...	6/...

Picklist Print

July 22, 2009 12:20:12 PM

Page 1

Work Order ID: 50724



Parent Item: D2017-121RevE



Parent Item Name: Step Strut

Start Date: 7/06/09

Required Date: 7/06/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			f		350.2300	2.1000			

304 RD Tube .750 x .049W

Warehouse

Location

Main Warehouse

MAT	350.2300026	
107518	7.27	
108498	0	
109314	8.5	
110113	0.73	
110271	0.03	
111096	9	
111457	11.43	
111619	13.2700026	
112187	300	

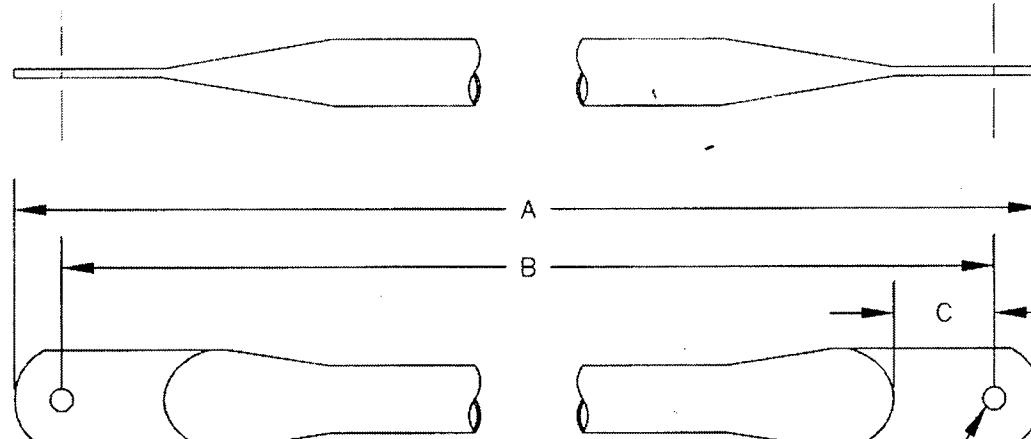
Loc Qty

Loc Code

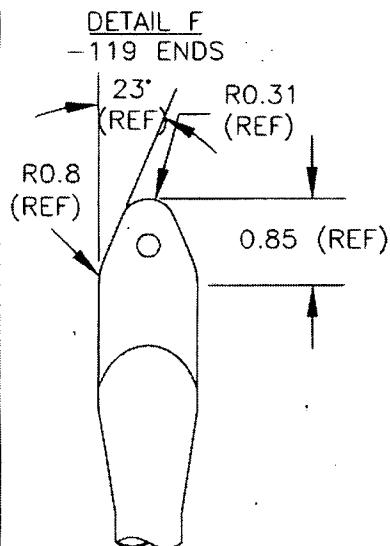
3.000

88 09/09/09

PUNCH ENDS PER
SPEC CTRL D2638
(-119 SEE NOTE)



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)
"E" DIA TO BE OPENED MANUALLY (ONE END ONLY)



NOTE:

FOR D2017-119: PUNCH PER D2638, GRIND ENDS PER DT8360 (SEE DETAIL F FOR REF.)
BEND FLARED ENDS 8° UP / 8° DOWN

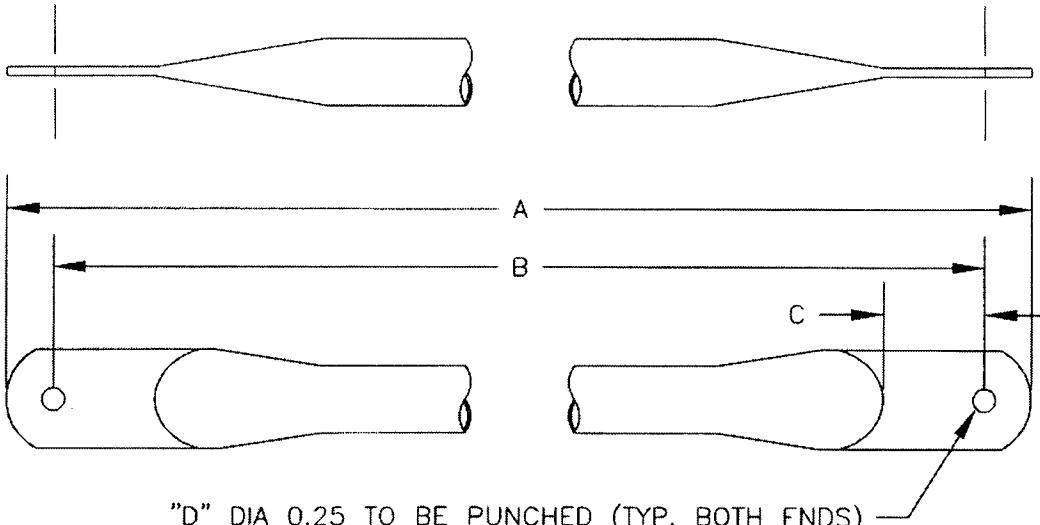
MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/0 SORRY
DART
DRAFT
DRAFT

BA COPY
DRAFT

Part Number	A	B	C	D	E
D2017-101	17.73	16.93	1.30	0.250	0.312
D2017-103	18.74	17.94	1.30	0.250	0.312
D2017-105	14.95	14.15	1.30	0.250	-
D2017-107	15.61	14.81	1.30	0.250	-
D2017-109	13.93	13.13	1.30	0.250	-
D2017-111	15.30	14.50	1.30	0.250	-
D2017-113	20.50	19.70	1.30	0.250	0.312
D2017-115	12.42	11.62	1.30	0.250	-
D2017-117	13.86	13.06	1.30	0.250	-
D2017-119	26.75	25.95	1.30	0.250	-
D2017-121	12.30	11.50	1.30	0.250	-
D2017-123	12.92	12.12	1.30	0.250	-
D2017-125	19.55	18.75	1.30	0.250	-
D2017-127	20.30	19.50	1.30	0.250	-
D2017-129	31.43	30.63	1.30	0.250	-
D2017-131	19.68	18.88	1.30	0.250	-
D2017-133	30.66	29.86	1.13	0.250	-

DESIGN	DRAWN BY	DART AEROSPACE LTD		
BW	APPROVED	DRAWING NO.	REV. E	SHEET 1 OF 2
<i>HE</i>	<i>HE</i>	D2017		
DATE		STEP STRUTS		SCALE
99.04.16				NTS
C	95.01.26	ADDED PARTS		
D	96.03.28	ADD PARTS		
E	99.04.16	ENDS PUNCHED PER SPEC CTRL -119 CHANGE (TSR A897)		



"D" DIA 0.25 TO BE PUNCHED (TYP. BOTH ENDS)

Part Number	A	B	C	D
D2017-201	21.31	20.51	1.30	0.250
D2017-203	16.39	15.59	1.30	0.250
D2017-205	16.53	15.73	1.30	0.250
D2017-207	13.85	13.05	1.30	0.250
D2017-209	15.64	15.33	1.30	0.250
D2017-211	15.67	14.87	1.30	0.250
D2017-213	15.82	15.02	1.30	0.250
D2017-215	16.47	15.67	1.30	0.250
D2017-217	16.70	15.90	1.30	0.250
D2017-219	13.65	12.85	1.30	0.250
D2017-221	13.58	12.78	1.30	0.250
D2017-223	12.95	12.15	1.30	0.250
D2017-225	13.99	13.19	1.30	0.250
D2017-227	30.67	29.87	1.30	0.250

NOTE:

MATERIAL: 304/316/318 SS, 0.75 OD x 0.049 WALL, ENSURE SEAMLESS TUBING IS USED
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FIG. 11. FUNDIC (AT 10°C (43.5°C) FOR 3000 MINUTES) (100).



DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
<i>[Signature]</i>	<i>[Signature]</i>	D2017	SHEET 2 OF 2
DATE	TITLE		SCALE
99.04.16	STEP	STRUTS	NTS